



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3370-3

Job Sheet 200380



Part No: D3370-3

Job Qty: 6 pcs

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP B 05.05.25 Added Powder Coat KJ/JLM IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs	10/8/19	10/8/19	0.00	0.20	Bandsaw - 1		19/10/1
110	HAAS 4 Axis - B4B	6 pcs	10/8/19	10/8/19	1.00	5.71	HAAS - 1 - B4B		DAS 23 9-89
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs	10/8/19	10/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

DAS
23
9-89

DAS
23
9-89



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Container No: S218850



Part: D3370-3

Job No: 200380

Serial No/Batch: S218850

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/01/19

Plex 9/10/19 3:16 PM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
QC 8 - 17					
QC 8 - 20					
QC 8 - 25					
QC 8 - 3					
QC 8 - 32					
QC 8 - 33					
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8	Done 19-10-01				
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
QC 8 - 76					
140 Handfinish - 1-1 Chemical-B4B	6 pcs	10/8/19	0.00 0.79	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 02 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	

					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 6 Fire Red - B4B	6	10/8/19	0.00 0.34	Powdercoat - 1 - B4B	
<i>11/29/2013 10:40</i> <i>START: 10:45 OUT: 3:00 FINISH: 11:15</i>					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	<i>BA 12-10-7</i>
					Powdercoat - 4 - B4B	
					QC 3 - 10	
160	QC 3	6	10/8/19	0.00 0.00	QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	DAS
					QC 3 - 24	81
					QC 3 - 61	9-89
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	6	10/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	<i>PC ST497</i>

9/10/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 QC 21 - SA	6 pcs	10/8/19	0.00 0.00	Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DMS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

OCT 08 2019

Part Op 100 - (Bandsaw) Cut blank: 1.500" x 2.500" x 4.120" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3370-3 as per Folio FA483 and Dwg D3370 Identify as D3370-3
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) Heat oven at temperature for 45 minutes before putting part in oven
 by: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	2.0898 ft (.3483 ea)	100-Bandsaw - 1	S207687

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	2	51	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 200380
Description: Pedal Lock Cover		Part Number: D3370-3
Inspection Dwg: D3370	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.980	✓		Vernier	VHJ-01
3.344	+/-0.010	3.346	✓		"	"
0.592	+/-0.010	0.592	✓		"	"
0.202	+/-0.010	0.202	✓		"	"
Ø1.000	+0.005/-0.000	1.000	✓		"	"
0.25	+/-0.030	0.260	✓		"	"
2.000	+/-0.010	1.9965	✓		"	"
0.300	+/-0.010	0.301	✓		"	"
0.550	+/-0.010	0.5525	✓		"	"
1.50	+/-0.030	1.4995	✓		"	"
Ø1.250	+0.005/-0.000	1.250	✓		"	"
0.635	+0.010/-0.000	0.6365	✓		"	"
Ø0.750	+0.010/-0.000	0.760	✓		"	"
1.673	+/-0.010	1.670	✓		"	"
0.430	+/-0.010	0.4265	✓		"	"
2.638	+/-0.010	2.637	✓		"	"
2.35	+/-0.030	2.348	✓		"	"
0.715 deep	+/-0.010	0.715	✓		"	"
15°	+/-0.1°	15°	✓		"	"
0.19 x 45°	+/-0.030	0.190	✓		"	"
0.450	+/-0.010	0.440	✓		"	"
1.450	+/-0.005	1.451	✓		"	"

Measured by: V.H.J.	Audited by: B.e.	Preliminary Approval:
Date: 19/9/26	Date: 19-10-01	Date:

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	
D	10.04.20	Dimensions revised per Dwg Rev C	KJ	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	DEPARTMENT/PROCESS	Date: _____ Sequence #: _____ Description Work Order Deviation	QTY Affected: _____ Disposition	MRB (QS1042)
				Completed By	QC / QA Coordinator
				Lead hand / Supervisor	

Root Cause	FAULT CATEGORY									
☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors	☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:										